

80007

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Customer:

6

6

Reference:

Run Start *NR1*

Date:

Stop ***NR2***

Date:

SPC (Y/N):

Date:

Draw Nbr	Revision Nbr	
D2198	Rev C	

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2198

34.063

Dwg Rev:

Prog Rev: _____

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80007

February-08-12 4:05:48 PM

80007

Page 2

Item ID: D2198-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 08/02/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 22/02/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo Bend as per dwg D2198	0.00 0.00				(6)			
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(46)			
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo POWDER COAT: Start Time: 1h35 Oven Temperature: 400°F Finish Time: 1h55	0.00 0.00				6	8.82	(OP)	12/03/12

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

February-08-12 4:05:48 PM

Item ID: D2198-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket
 Start Date: 08/02/2012 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 22/02/2012 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									

170	Identify as per dwg & Stock Location	0.00							
170									
Packaging	Memo	0.00							
Packaging									

180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/3/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

February-08-12 4:05:52 PM

Page 1

Work Order ID: 80007

80007

Parent Item: D2198-1

D2198-1

Parent Item Name: Bracket

Start Date: 08/02/2012

Required Date: 22/02/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-07-24 new issue ec verified by:dd IPP rev:B
10.05.03 add powdercoat DD verified :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

9.4700

0.125

0.789474

**

M304S16GA

304/316 Sheet .063

12.03.06

Location

Loc Qty

Loc Code

MAT020

9.47

120243

9.47

120877

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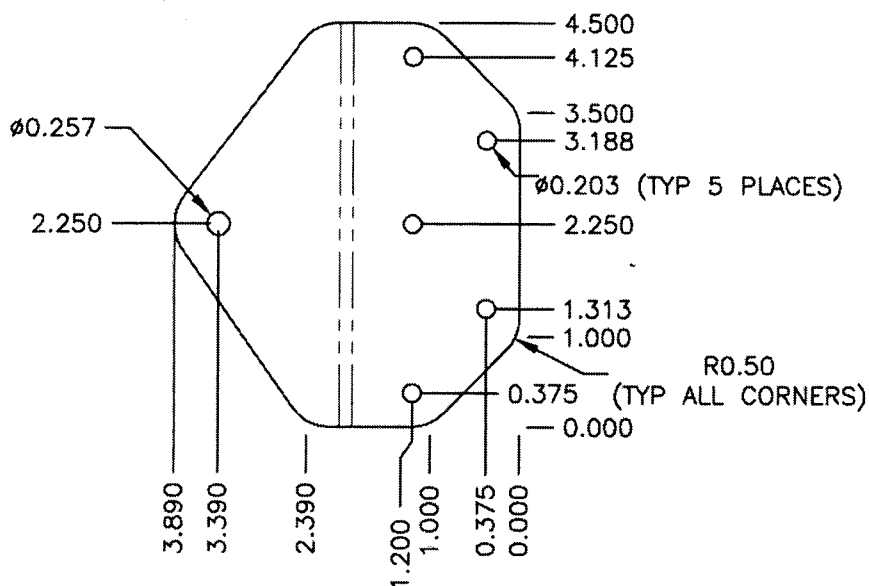
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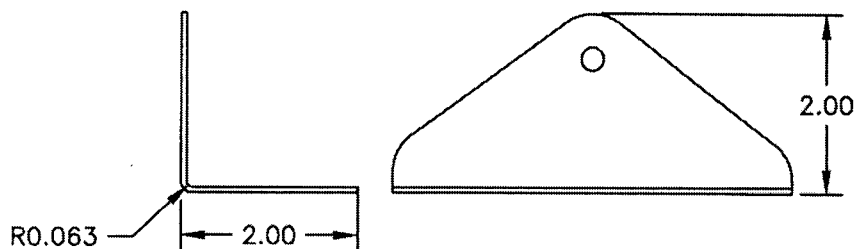
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2198	REV. C SHEET 1 OF 1
DATE 03.05.28		TITLE BRACKET	SCALE 1:2
B	93.10.05	REDESIGN	
C	03.05.28	REDRAW	

RELEASED
03.07.09



D2198-1
FLAT PATTERN

UNCLASSIFIED
SERIAL
80007 HLT
12/02/08



D2198-1 BRACKET
BEND DETAIL

D2198-1

- 1) MATERIAL: AISI 304/316 S.S. 0.064" THICK (M304S16GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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